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(54) **Oxazoline latex for tire cord adhesion.**

(57) A latex is prepared by polymerizing (a) an addition polymerizable oxazoline (such as 2-isopropenyl-2-oxazoline) and (b) at least one other monomer (such as a mixture of styrene and butadiene). The latexes of this invention are useful for promoting adhesion between a polymeric elastomer and a substrate, especially for promoting adhesion between tire cords and tire rubber.

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OXAZOLINE LATEX FOR TIRE CORD ADHESION

5 This invention relates to latexes polymerized from an oxazoline monomer, and to uses of such latexes as adhesion promoters for substrates in polymeric elastomers, especially for adhesion of tire cord to tire rubber.

10 Polymeric elastomers such as natural and synthetic rubber are extremely useful due to their elongation, resiliency, lack of permeability, high coefficient of friction, etc. However, when used by themselves, these materials are generally lacking in critical mechanical properties such as tensile strength. Therefore, it has been a standard practice in the industry to use reinforcing materials such as fibers in the manufacture of articles from polymeric elastomers. One problem with this approach, however, is that it is generally difficult to obtain good adhesion between the reinforcing material and the elastomer.

When Robert William Thompson patented the first pneumatic tire in England in 1845, the use of textile fabric as the strength member of a tire was established. The term tire "cord" became common when
5 in 1893 John Fullerton Palmer patented the use of thread or tire cord in England and in the U.S. It was not until after World War I, however, when automobiles really became popular in the U.S., that square woven cotton tire fabric was commercially discarded in favor
10 of several plies of rubber coated, warp cotton cords.

In the 1930's the first man-made fiber, rayon, a regenerated cellulose, was introduced into tires. Since rayon was spun in a continuous filament form, it had greater uniformity as cord than ordinary
15 cotton cord. However, it lacked one of the important features of cotton, and that was good adhesion to the tire rubber. Adhesive dips such as casine and animal blood dispersions which produced satisfactory results for cotton cord were not effective for rayon. But the
20 adhesion problem was partially solved when a World War II development effort resulted in the discovery of resorcinol-formaldehyde latex (RFL) adhesive systems. While not totally satisfactory, the RFL systems were the best available, and in fact represent the dominant
25 commercial system in use today.

But whether rayon, nylon, polyester, glass or other fibers are used, the industry still desires better adhesion between the tire cord and the tire rubber.

30 In one aspect the invention is a latex which comprises discrete polymer particles which have been

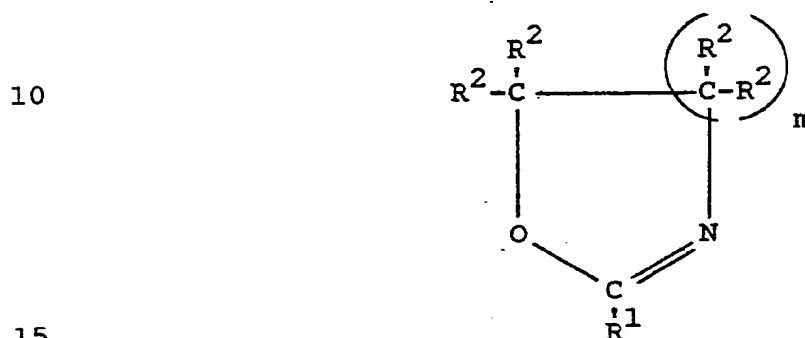
polymerized from (a) an addition polymerizable oxazoline in an amount such that the latex will produce greater adhesion between a substrate and a polymeric elastomer than a similar latex not having the oxazoline, and (b) at least one other monomer. In another aspect, the invention is an article comprising (a) an adhesion promoting amount of the aforementioned latex, (b) a polymeric elastomer, and (c) a substrate, wherein the substrate and elastomer are tenaciously bonded to one another, the strength of said bond being greater than if the latex were not present.

The latexes of the invention are useful for bonding a wide variety of substrates to a wide variety of polymeric elastomers, including the bonding of tire rubber to tire cords.

The practice of the invention contemplates the emulsion polymerization of a synthetic latex. By the term "latex" is meant colloidally stable dispersions of discrete water-insoluble particles in an aqueous medium, which are produced by emulsion polymerization. Latexes useful in the invention are generally water-insoluble. They generally have a number average particle diameter of desirably about 20 to about 2,000 nm (nanometers; 10^{-9} meters), more desirably about 50 to about 1,000 nm, and preferably about 100 to about 220 nm. The latexes are typically prepared in an alkaline aqueous medium with the aid of a surfactant. Alkaline conditions are preferably employed to prevent acid hydrolysis of the oxazoline ring. Selection of an alkaline surfactant may provide

sufficient pH control. In any event, a common base such as NaHCO_3 , NH_4OH , NaOH , etc. may be used to adjust the pH.

As a first component, the latexes of the invention employ an addition polymerizable oxazoline monomer. Desirably, the oxazoline monomer is represented by the formula



wherein R^1 is an acyclic organic radical having addition polymerizable unsaturation, each R^2 separately denotes a hydrogen atom, a halogen or an organic radical, and m is 1 or 2. In a preferred embodiment, at least two of R^2 are hydrogen atoms and m is 1. In a more preferred embodiment, all of R^2 are hydrogen atoms and m is 1. In a preferred embodiment, R^1 is an isopropenyl radical. In the most preferred embodiment, R^1 is an isopropenyl radical, all of R^2 are hydrogen atoms and m is 1 (2-isopropenyl-2-oxazoline).

In addition to the polymerizable oxazoline monomer, at least one other addition polymerizable monomer will be used. As the "other monomer", virtually all addition polymerizable compounds which, when

copolymerized with the oxazoline monomer will result in a latex, may be used. Preferred species include monovinyl aromatic monomers, acyclic aliphatic conjugated dienes, esters of unsaturated acids with saturated alcohols, and esters of saturated acids with unsaturated alcohols.

The term "monovinyl aromatic monomer" is intended to include those monomers wherein a radical of the formula:



(wherein R is hydrogen or a lower alkyl such as an alkyl having from 1 to 4 carbon atoms) is attached directly to an aromatic nuclear containing from 6 to 10 carbon atoms, including those wherein the aromatic nucleus is substituted with alkyl or halogen substituents. Typical of these monomers are styrene, α -methylstyrene, ortho-, meta- and para-methylstyrene; ortho-, meta- and para-ethylstyrene; o,p-dimethylstyrene; o,p-diethylstyrene; isopropylstyrene; o-methyl-p-isopropylstyrene; p-chlorostyrene; p-bromostyrene; o,p-dichlorostyrene; o,p-dibromostyrene; vinyl naphthalene; diverse vinyl (alkyl naphthalenes) and vinyl (halonaphthalenes) and comonomeric mixtures thereof. Because of considerations such as cost, availability, ease of use, etc., styrene and vinyltoluene are preferred and styrene is especially preferred as the monovinyl aromatic monomer.

The term "acyclic aliphatic conjugated diene" is meant to include, typically, those compounds containing from 4 to about 9 carbon atoms such as, for example, 1,3-butadiene, 2-methyl-1,3-butadiene; 2,3-dimethyl-1,3-butadiene; pentadiene; 2-neopentyl-1,3-butadiene and other hydrocarbon analogs of 2,3-butadienes, such as 2-chloro-1,3-butadiene; 2-cyano-1,3-butadiene, the substituted straight chain conjugated pentadienes, the straight chain and branched chain conjugated hexadienes, other straight and branched chain conjugated dienes having from 4 to about 9 carbon atoms, and comonomeric mixtures thereof. The 1,3-butadiene hydrocarbon monomers such as those mentioned hereinbefore provide interpolymers having particularly desirable properties and are therefore preferred. The cost, ready availability and the excellent properties of interpolymers produced therefrom makes 1,3-butadiene the most preferred acyclic aliphatic conjugated diene.

The term "esters of unsaturated acids with saturated alcohols" is meant to include, typically, soft acrylates (i.e., those whose homopolymers have a glass transition temperature (T_g) of less than about 25°C) such as benzyl acrylate, butyl acrylate, sec-butyl acrylate, cyclohexyl acrylate, dodecyl acrylate, ethyl acrylate, 2-ethylbutyl acrylate, 2-ethylhexyl acrylate, heptyl acrylate, hexyl acrylate, isobutyl acrylate, isopropyl acrylate, methyl acrylate, propyl acrylate, etc.; hard acrylates (i.e., those whose homopolymers have a T_g of greater than about 25°C) such as 4-biphenyl acrylate and tert-butyl acrylate; soft methacrylates such as butyl methacrylate, and hexyl methacrylate; and hard methacrylates such as

sec-butyl methacrylate, tert-butyl methacrylate, cyclohexyl methacrylate, ethyl methacrylate, isobutyl methacrylate, isopropyl methacrylate, methyl methacrylate, propyl methacrylate, etc.

- 5 The cost, availability and known properties of butyl acrylate and ethyl acrylate make these monomers preferred among the acrylates. The cost, availability and known properties of methyl methacrylate make it preferred among the methacrylates.

- 10 The term "esters of saturated acids with unsaturated alcohols" is meant to include, typically, vinyl acetate, vinyl propionate, vinyl butyrate, vinyl 2-ethylhexoate, vinyl benzoate, and the like. The low cost and ready availability of vinyl acetate makes it
15 desirable for use in the invention.

- As the other monomer, it is often desirable to employ a mixture of two or more monomers. For instance, latexes having both a hard ester and a soft ester, and those having both an acyclic aliphatic
20 conjugated diene and a monovinyl aromatic monomer are especially well known, convenient to make, and have predictable and useful properties.

- Especially in instances where preferred classes of monomers are used, it may be desirable to
25 include other monomers in minor amounts, so long as the final properties of the latex are not significantly impaired. For instance, when 2-isopropenyl-2-oxazoline, styrene, and 1,3-butadiene are used, it may be desirable to include minor amounts (e.g.,
30 2 weight percent) of a water-soluble monomer such as acrylamide.

The proportions of monomers used in the latex may vary considerably, depending on the particular end use of the binding composition. If more than one "other" monomer is used, they will
5 be present in relative proportion according to the desired properties of the finished latex. The oxazoline monomer is present in an amount to increase adhesion of a substrate to a polymeric elastomer compared to a similar latex prepared
10 without the oxazoline. Typically, the latex monomer charge will have desirably about 0.1 to about 50, preferably about 0.2 to about 20 weight percent oxazoline monomer, the remainder being other monomer.

The latexes are conveniently prepared by
15 conventional emulsion polymerization techniques in an aqueous medium with conventional additives. Thus, for example, the monomer charge desired to be employed for the latex is dispersed in an alkaline aqueous medium with agitation and with the aid of from about 0.5 to
20 about 5 weight percent (based upon the monomer charge) of conventional anionic and/or nonionic emulsifiers (e.g., potassium n-dodecyl sulfonate, sodium isooctylbenzene sulfonate, sodium laurate, nonylphenol ethers of polyethylene glycols, modified rosin soaps, and the
25 like) and thereafter polymerizing the resulting aqueous dispersion.

Conventional emulsion polymerization catalysts can be employed in the foregoing latex polymerization and common examples thereof include
30 peroxides, persulfates, azo compounds and the like such as sodium persulfate, potassium persulfate,

ammonium persulfate, hydrogen peroxide, azodi-isobutyric diamide as well as catalysts (e.g., redox catalyst) which are activated in the water phase (e.g., by a water-soluble reducing agent).

5 Typically, such catalyst are employed in a catalytic amount, e.g., ranging from 0.01 to about 5 weight percent based upon the monomer weight. In general, the polymerization is conducted at a temperature in the range of from about -20° to about 110°C (prefer-
10 ably from about 0° to about 90°C) and at a pH of from about 7 to about 12, preferably from about 7 to about 11 and especially from about 7.5 to about 9.5.

Similarly, conventional chain transfer
15 agents such as, for example, n-dodecyl mercaptan, bromoform, carbon tetrachloride and the like can also be employed in the normal fashion in the aforementioned first stage polymerization to regulate the molecular weight of the polymer formed therein, and,
20 typically, when such chain transfer agents are used, they are employed in amounts ranging from 0.01 to about 10 (preferably from about 0.1 to about 5) weight percent based upon the weight of the monomers employed in the polymerization.

25 After polymerization, the latexes are preferably processed to remove any unreacted monomer.

Suitable latex polymerization procedures are taught, for instance, in U.S. Patent Nos. 4,325,856;
30 4,001,163; 3,513,121; 3,575,913; 3,634,298; 2,399,684; 2,790,735; 2,880,189; and 2,949,386.

The practice of the invention contemplates the use of the latex to promote adhesion between a polymeric elastomer and substrate. By "elastomer" is meant any polymeric material which has the ability
5 to stretch at least about two times its length, and to rapidly return to its original dimensions when the stretching force is removed. Preferred polymeric elastomers include natural rubber and synthetic rubber such as those made from various combinations of styrene,
10 1,3-butadiene, and 2-methyl-1,3-butadiene (also known as isoprene).

As the substrate, virtually any nonelastomeric material may be used. Materials such as metals, concrete, rock, wood, glass and thermoset and thermoplastic
15 polymers are suitable for use as the substrate. More preferred as a substrate are fibrous materials, especially those in the form of threads or cords. Suitable fibers include polymeric fibers such as nylon, rayon, polyester, and aramid; and mineral fibers such as
20 fiberglass.

The latex, elastomer, and substrate may be combined together in any manner in which the latex will promote adhesion of the elastomer to the substrate. One suitable method is to blend the latex with the
25 elastomer prior to joining the elastomer to the substrate. A more preferred method, however, is to pre-coat the substrate with the latex, allowing it to dry on the substrate, heat treating the latex, and then joining the substrate to the elastomer. Once
30 the elastomer and substrate are contacted, any normal curing processes may be used. For instance, it is conventional when using synthetic rubbers to vulcanize

the rubber by applying pressure and heat. This induces crosslinking of the polymer chains via sulfur bridges. Other suitable curing mechanisms are also usable in this invention.

5 In a particularly preferred embodiment, the latexes of the invention are used to promote the adhesion of tire cords to tire rubber. In this preferred embodiment, the tire cord, in the form of a continuous strand, may be conveniently run through a latex bath,
10 dried, cured at elevated temperature, and returned to a spool, or taken directly to a tire building machine. A conventional tire rubber mixture containing sulfur for vulcanization is then used as the tire carcass. After the tire has been molded, it is subjected, in
15 a conventional manner to heat and pressure to cure the rubber. Tires produced in this manner have extremely good rubber to cord adhesion.

 The invention is further illustrated and explained in the following examples. In the examples,
20 all parts and percentages are by weight unless otherwise specified.

Example 1

 A series of latexes were prepared using conventional emulsion polymerization techniques and, per
25 100 parts of monomer, 147.75 parts of water, 0.01 part VERSENEX[®] 80 chelating agent (pentasodium salt of (carboxy methylimino)bis(ethylenenitrilo)tetraacetic acid, available from The Dow Chemical Company, Midland, MI, USA), 5.0 parts of Dresinate 214 (potassium soap of
30 a modified rosin, available from Hercules, Inc., Wilmington, DE, USA), 0.50 part of sodium persulfate,

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and 0.5 part of t-dodecylmercaptan. As the monomers, various proportions of styrene, 1,3-butadiene, and 2-isopropenyl-2-oxazoline were used. The reaction mixture was polymerized at 60°C for 8 hours, cooled, and chain terminated with 0.5 part of sodium dimethyldithiocarbamate. Unreacted monomer was then removed until the residual 2-isopropenyl-2-oxazoline present was less than 10 ppm. Then, 500 ppm formaldehyde were added as a biocide, and 1 percent of a conventional antioxidant package was added.

A 3-ply polyester tire cord was dipped into the latex, suspended between two fixed points (to prevent shrinkage), and cured in an oven for 145 seconds at 85°C and then for 90 seconds at 190°C.

15 Into the right side of a shallow, rectangular mold cavity, a pad of fully cured black rubber was placed. Into the left side of the cavity was placed an uncured rubber pad with a nylon backing, and on top of that was placed an uncured rubber pad without a nylon backing. The cured rubber pad had a thickness which was roughly equal to the combined thickness of the two uncured rubber pads. Then, sections of treated tire cord were laid across the rubber pads, perpendicular to the interface between the cured and uncured rubber. Then, a second cured rubber pad was placed over the first cured rubber pad. Similarly, on the left side of the mold, a second uncured rubber pad without nylon backing was placed on the first such pad, and this was followed by a second uncured rubber pad with nylon backing.

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The rubber pads, which have the tire cords sandwiched between, were then molded at 160°C, 800 psi (5.5 megapascals) for 10 minutes. The rubber was then removed from the mold and allowed to cool. Since the rubber on the right side of the mold was cured before the molding operation, it did not stick to the tire cords and was easily removed. The result was a cured rubber composite (the rubber from the left side of the mold) having tire cords extending perpendicularly from an edge toward what was the right side of the mold.

A cut was then made into the rubber specimen along a line perpendicular to the tire cords, and 1/4 in. (6.35 mm) from the edge from which the tire cords protrude. This cut was sufficiently deep to sever the tire cords but sufficiently shallow that the lower piece of the nylon backing remained intact. The section of cured rubber distal to the protruding tire cords was then placed in one jaw of an Instron tester. The free end of a single tire cord was then placed in the other jaw of the tester. The tester was then run at a jaw speed of 5 in./min. (127 mm/min.) to determine the force required to pull the cord out of the rubber. Since the cut into the rubber left only 1/4 in. of tire cord in the rubber, a direct reading from the Instron machine must be multiplied by 4 to express the result in lbs/in. The testing procedure was then repeated for the remaining cords in the sample, and the entire procedure repeated for the remaining latexes. The results are shown in Table I.

Comparative Example 1

Following the procedure of Example 1, a latex was made without the 2-isopropenyl-2-oxazolin , and a latex was made having 2-vinyl pyridene present as a monomer. These results are shown in Table I.

Example 2 and Comparative Example 2

The procedures of Example 1 and Comparative Example 1 were repeated, except that the tire cords were dipped not into the pure latex, but rather were dipped into a mixture of the following ingredients.

		<u>Dry Basis</u>	<u>Wet Basis</u>
	<u>Resin Solution</u>		
	Penecolite Resin R-2200 (70%) ¹	12.6	18.0
	Sodium Hydroxide (50%)	0.3	0.6
15	Formaldehyde (37%)	4.5	12.2
	Water (deionized)	--	175.0
	<u>Final RFL Mix</u>		
	Latex (40%)	100.0	250.0
	Ammonium Hydroxide (28%)	--	12.0
20	Water (deionized)	--	65.8
	Totals	117.4	533.6

Total Percent Solids = 22.0

¹Penacolite is a registered trademark of the Koppers Company, Inc.

25 This mixture was prepared by adding the 50 percent sodium hydroxide to the water, adding the Penacolite resin, agitating for 10 minutes, and adding the formaldehyde, followed by another 5 minutes of agitation. Then, the latex, ammonium hydroxide,

and water were added, in order, to the above mixture. The mixture was then allowed to age at room temperature for at least 12 hours before use. The results are shown in Table II.

5 Example 3 and Comparative Example 3

The procedures of Example 2 and Comparative Example 2 were repeated except that tire cords made of nylon 6,6 were used instead of polyester. The results are shown in Table III.

TABLE I

POLYESTER/NEAT LATEX

<u>Sample</u>	<u>Butadiene</u>	<u>Styrene</u>	<u>IPO¹</u>	<u>2-Vinyl Pyridine</u>	<u>% Pickup</u>	<u>Adhesion (lbs/inch)</u>
1-1*	70	30	--	--	12.2	8.7
1-2	70	25	5	--	7.9	30.0
1-3	70	20	10	--	16.1	25.1
1-4*	70	15	--	15	12.8	23.9

* Not an example of the invention.

¹IPO is 2-isopropenyl-2-oxazoline

TABLE II

POLYESTER/RFL MIX

<u>Sample</u>	<u>Butadiene</u>	<u>Styrene</u>	<u>IPO¹</u>	<u>2-Vinyl Pyridine</u>	<u>% Pickup</u>	<u>Adhesion (lbs/inch)</u>
2-1*	70	30	--	--	6.4	24.0
2-2	70	25	5	--	7.2	48.5
2-3	70	20	10	--	7.6	32.5
2-4*	70	15	--	15	7.4	26.1

* Not an example of the invention.

¹IPO is 2-isopropenyl-2-oxazoline

TABLE III

NYLON 6,6/RFL MIX

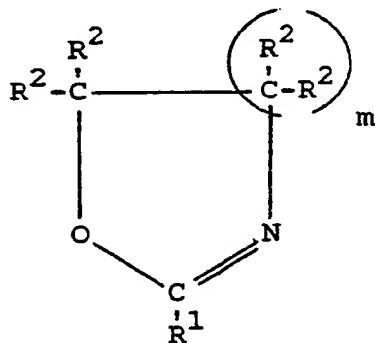
Sample	Butadiene	Styrene	IPO ¹	2-Vinyl Pyridine	% Pickup	Adhesion (lbs/inch)
3-1*	70	30	--	--	7.4	68.0
3-2	70	25	5	--	8.2	83.5
3-3	70	20	10	--	7.9	93.2
3-4*	70	15	--	15	7.3	85.0

* Not an example of the invention.

¹IPO is 2-isopropenyl-2-oxazoline

1. A latex comprising discrete polymer particles which have been polymerized from
 - (a) an addition polymerizable oxazoline in an amount such that the latex will produce greater adhesion between a substrate and a polymeric elastomer than a similar latex not having the oxazoline; and
 - (b) at least one other monomer.

2. The latex of Claim 1 wherein the addition polymerizable oxazoline is represented by the formula



wherein R^1 is an acyclic organic radical having addition polymerizable unsaturation, each R^2 separately denotes a hydrogen atom, a halogen or an organic radical, and m is 1 or 2.

3. The latex of Claim 2 wherein the addition polymerizable oxazoline is 2-isopropenyl-2-oxazoline.

4. The latex of Claim 1 wherein the other monomer comprises a monovinyl aromatic monomer and an acyclic aliphatic conjugated diene.

5. The latex of Claim 4 wherein the monovinyl aromatic monomer is styrene and the acyclic conjugated diene is 1,3-butadiene.

6. The latex of Claim 1 wherein the other monomer comprises an ester of an unsaturated acid with a saturated alcohol.

7. The latex of Claim 1 wherein the addition polymerizable oxazoline is present at about 0.5 to about 10 parts by weight, based on the total monomer charge.

8. The latex of Claim 2 wherein the addition polymerizable oxazoline is present at about 0.5 to about 10 parts by weight, based on the total monomer charge.

9. The latex of Claim 5 wherein the addition polymerizable oxazoline is present at about 0.5 to about 10 parts by weight, based on the total monomer charge.

10. A composite comprising
(a) a polymeric elastomer,
(b) a substrate and
(c) an adhesion promoting amount of the latex of claim 1
wherein the elastomer is adhesively bound to the substrate,
and such adhesion is more tenacious than if the latex
were not present.

11. The composite of Claim 10 wherein the
latex has been coated onto the substrate, and dried.

12. The composite of Claim 11 wherein the
latex coated substrate is dried at a temperature of
about 105°C or higher.

13. The composite of Claim 10 wherein the
elastomer is natural rubber or a synthetic rubber made
from styrene and 1,3-butadiene.

14. The composite of Claim 10 wherein the
substrate is a fiber.

15. The composite of Claim 14 wherein the
fiber is polyester, nylon 6,6, rayon, or fiberglass.

16. The composite of Claim 10 in which the
composite is a pneumatic tire.

17. The composite of Claim 13 wherein the
addition polymerizable oxazoline is 2-isopropenyl-2-
-oxazoline.

18. The composite of Claim 16 wherein the
addition polymerizable oxazoline is 2-isopropenyl-2-
-oxazoline.



European Patent
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EUROPEAN SEARCH REPORT

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Application number

EP 83 11 1947

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 2)
X	DE-A-2 012 810 (BAYER) * Claims 1,3; page 5, lines 5,11; page 4, lines 17-19; page 7, line 26 *	1-9	C 08 F 226/06 C 08 F 246/00 C 08 J 5/06
Y	* Page 14, line 7 *	10-18	
X	--- US-A-2 897 182 (P.L. DE BENNEVILL et al.) * Claim 1; column 10, lines 45-68, 69-70 *	1-3,6-9	
Y	* Column 11, line 70 *	10-18	
Y	--- DE-B-1 287 039 (HÜLS) * Claim 1 *	10-18	TECHNICAL FIELDS SEARCHED (Int. Cl. 2)
	-----		C 08 F C 08 J
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 09-03-1984	Examiner VAN HUMBEECK F.W.C.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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